

Date: Tuesday, 4/25/2006 7:35:58 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 26804		
Estimate Number	: 12394		
P.O. Number	: N/A	Part Number	: D33533
This Issue	: 4/25/2006 S.O. No. : N/A	Drawing Number	: D3353 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 5/31/2006
Checked & Approved By	: <u>06.04.25</u>	Qty:	16 Um: Each
Comment	: est rev 06.04.24 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1018B400X250	Inventory
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Comment: Qty.: 0.4200 f(s)/Unit Total : 1.6800 f(s)  
 1010-1025 BAR .25" thick x 4.00" batch: M16210

ML 06 05 02 (16)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D  
 Dwg Rev: A  
 Prog Rev: A

ML 06 05 02

(16)

2-Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EC ML 06 05 02 (16)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06-05-03 16

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: 5741

06/5/3 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes NO DQA: S Date: 26/05/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 26804

Part Number: D33533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

DP 06/05/04 (16)

Job Completion



W 06/05/04

**Dart Aerospace Ltd**



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

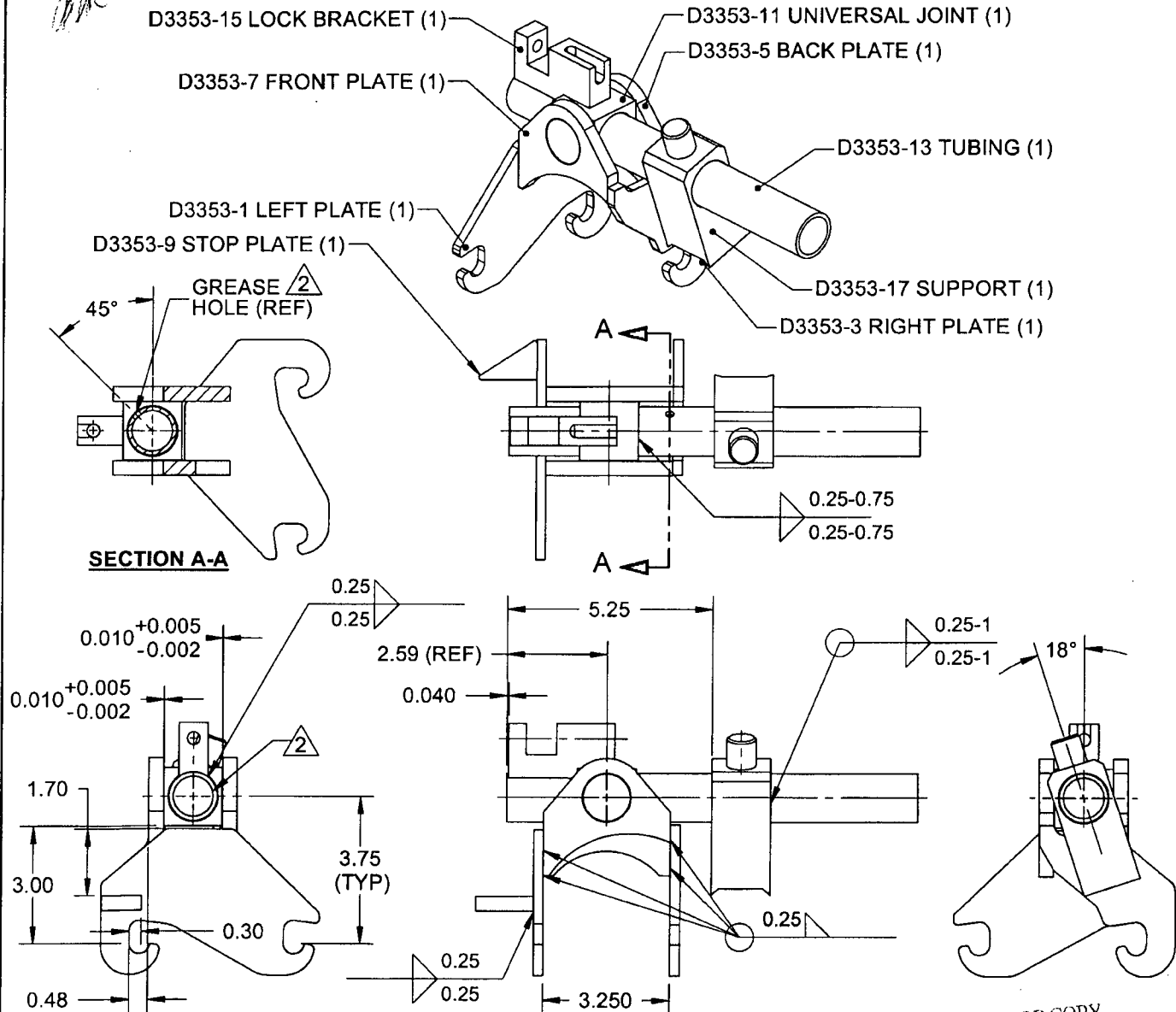
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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DATE <b>04.12.14</b>		TITLE <b>LUG WELDMENT</b>	SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED  
26/02/06



## D3353-041 LUG WELDMENT

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

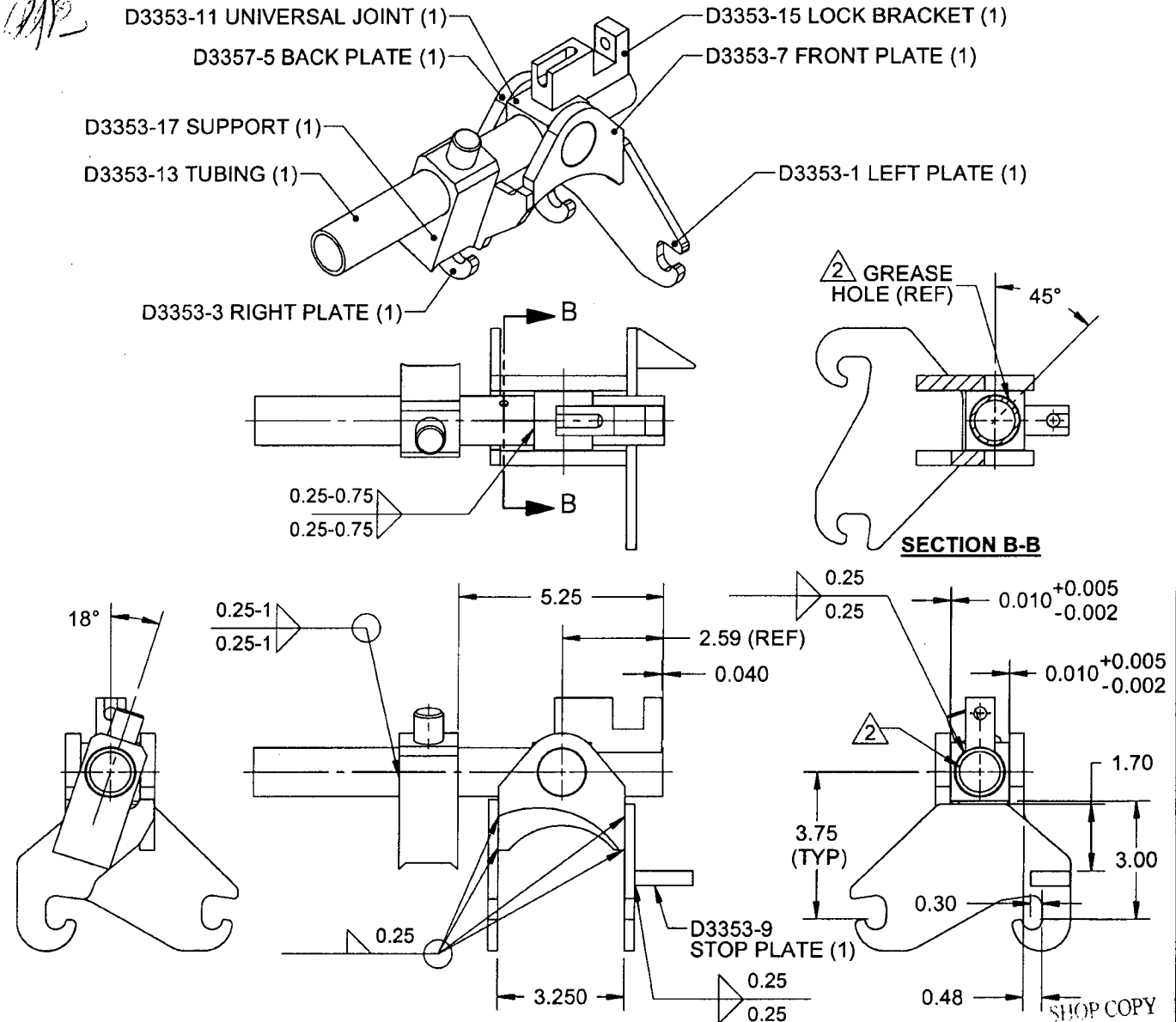
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SI 005 4/3 WITHOUT NOTICE  
NOTED WORK ORDER  
NO. 26804

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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:4

**RELEASED**  
*05/03/59***D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

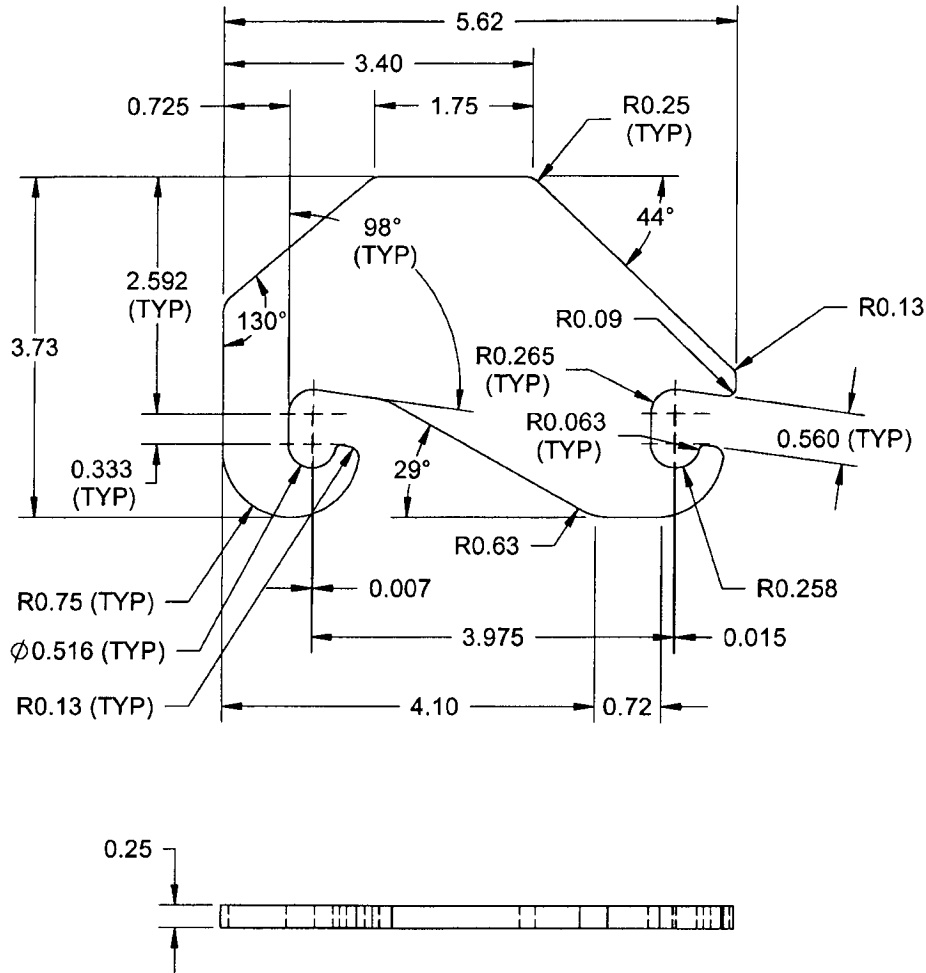
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:2

**RELEASED**  
**01/05/14****D3353-1 LEFT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

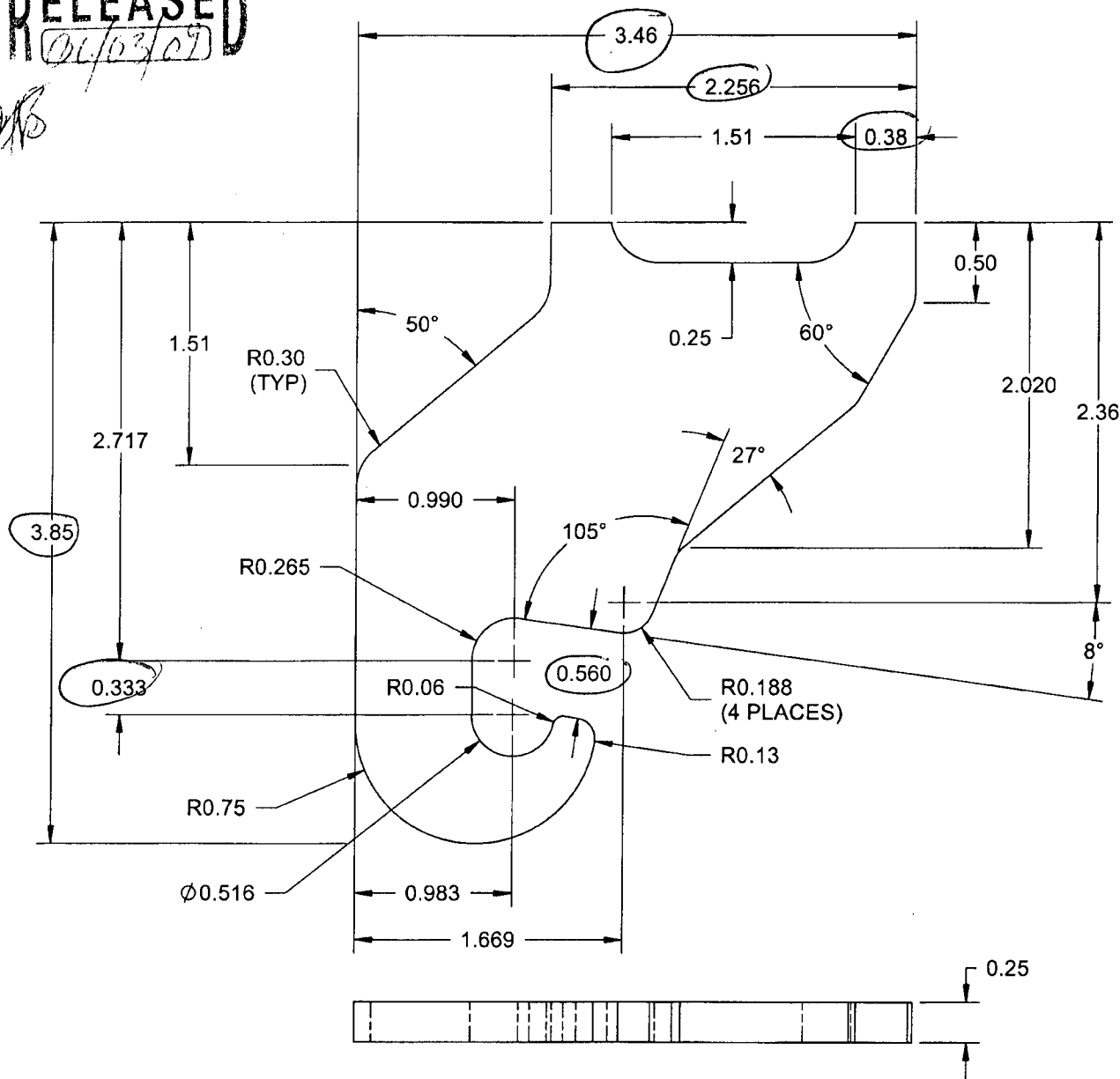
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**RELEASED**  
*04/03/07***D3353-3 RIGHT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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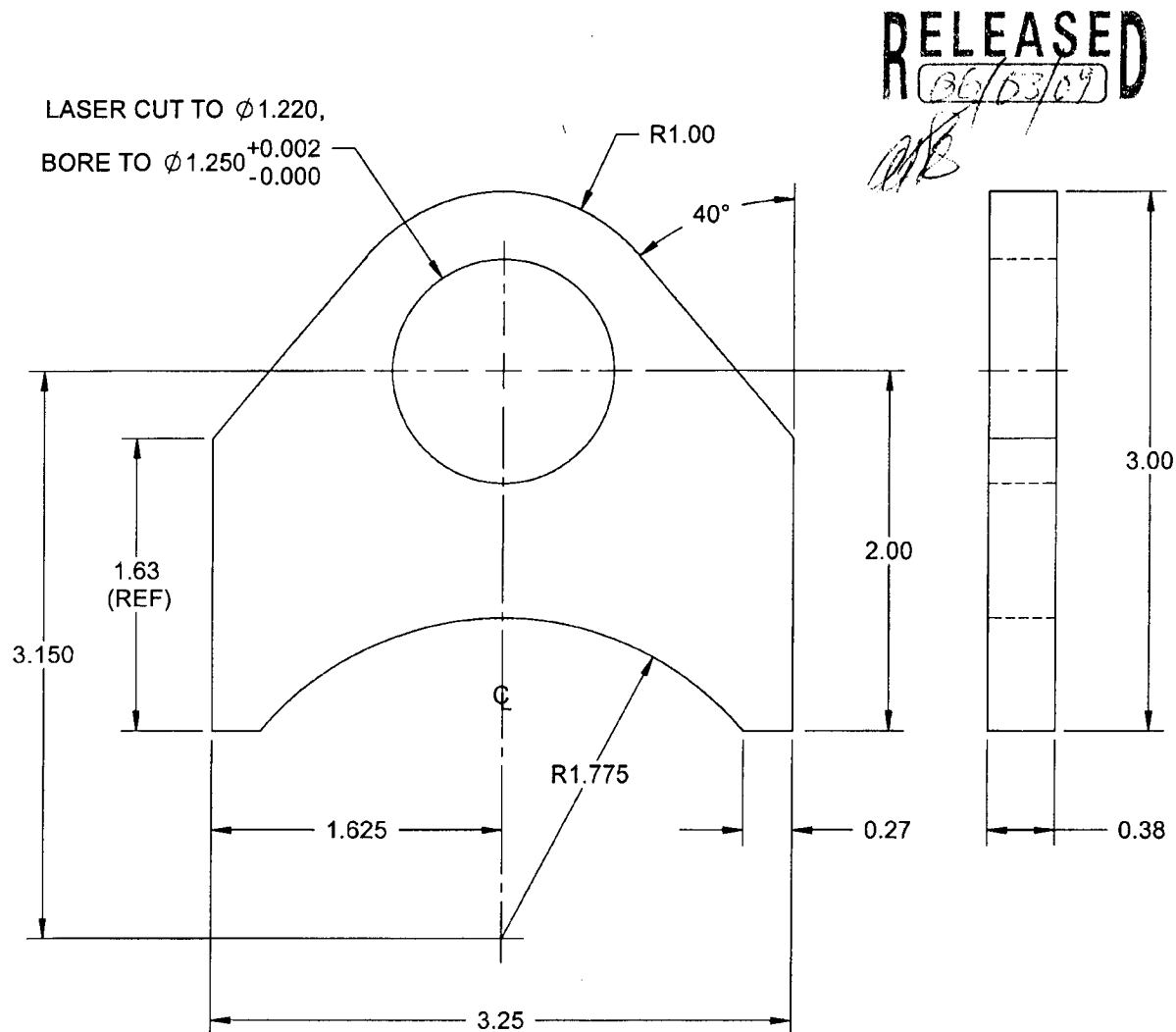
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**D3353-5 BACK PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

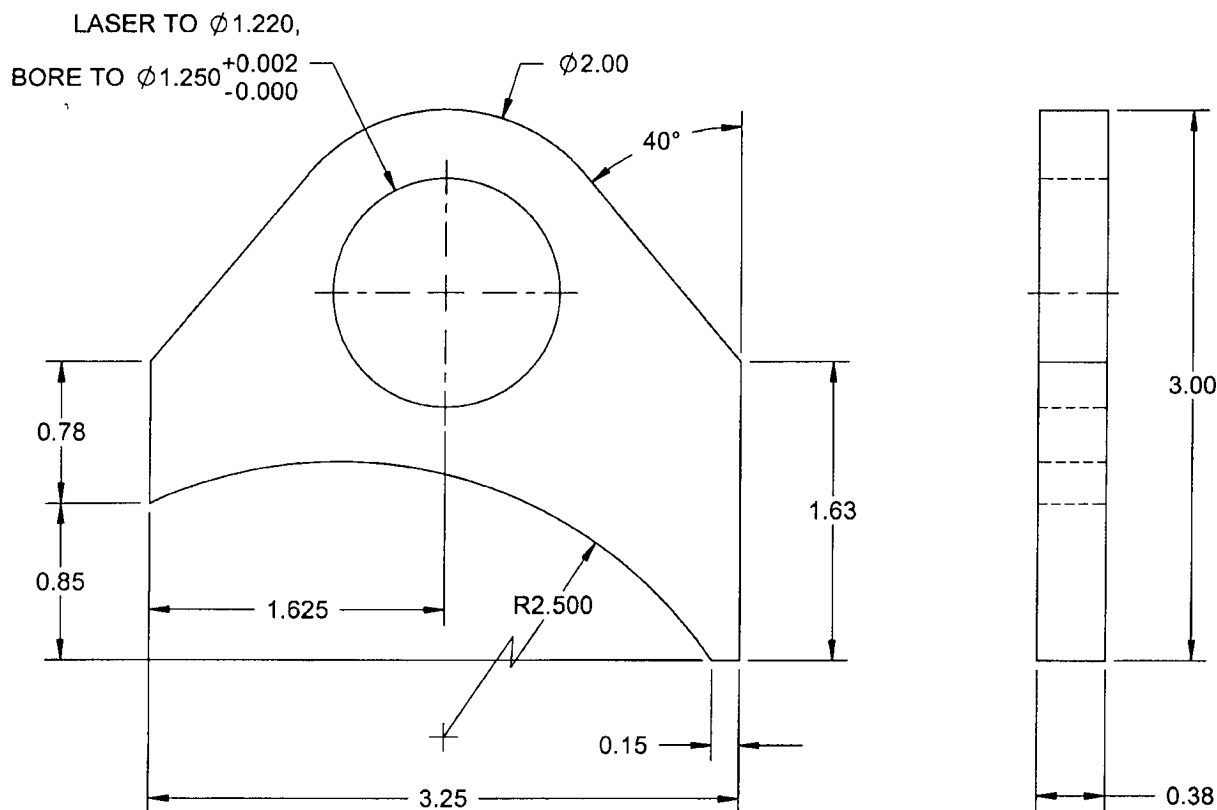
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**RELEASED**  
*[Stamp]***D3353-7 FRONT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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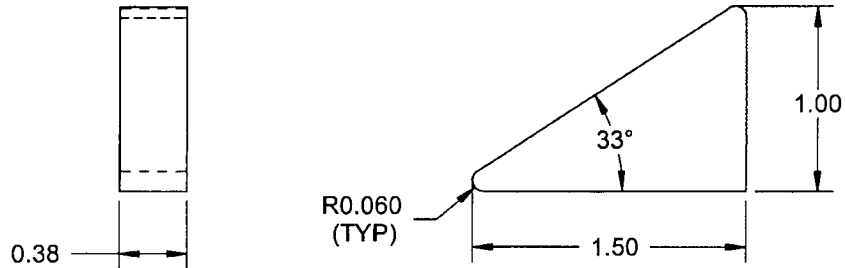
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

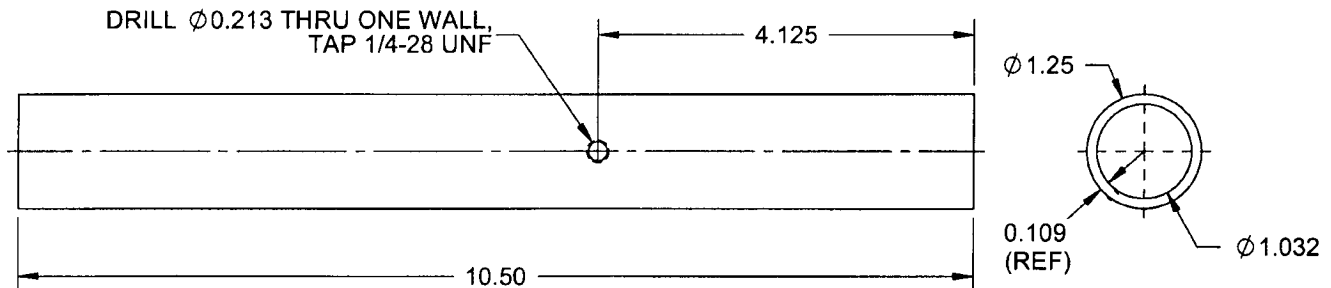
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3/3/09

[Signature]



### D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK  
MILD STEEL BAR (REF. DART SPEC. M1010-B)



### D3353-13 TUBING

#### NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,  
Ø 1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING  
(REF. DART SPEC. M1020TR1.250W.109)

#### NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

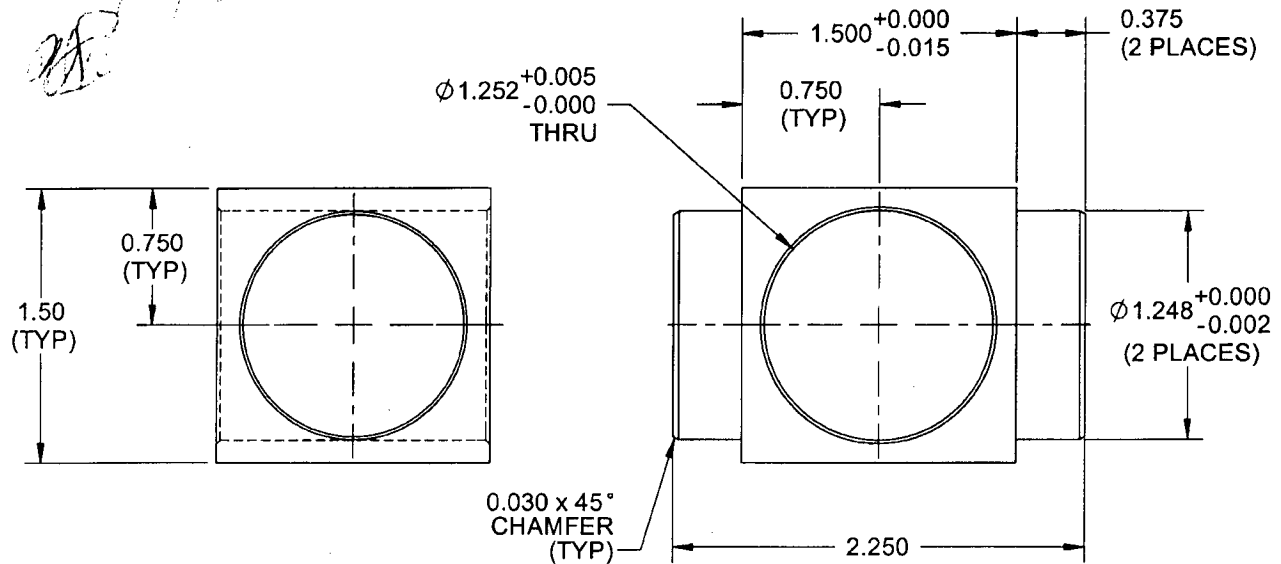
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**RELEASED**  
04/33/07**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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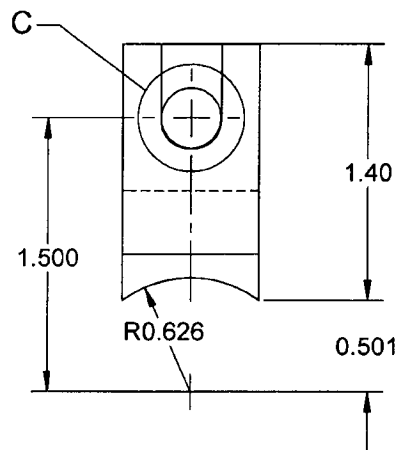
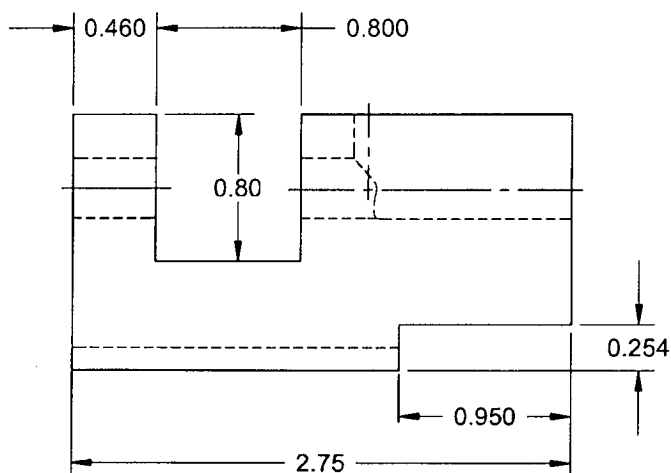
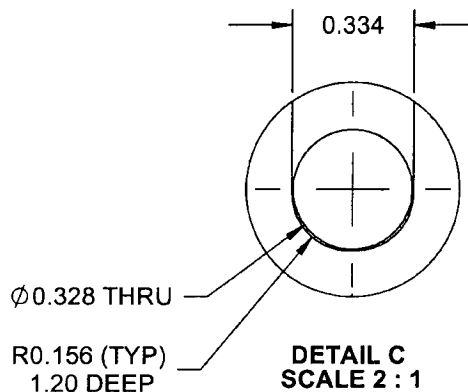
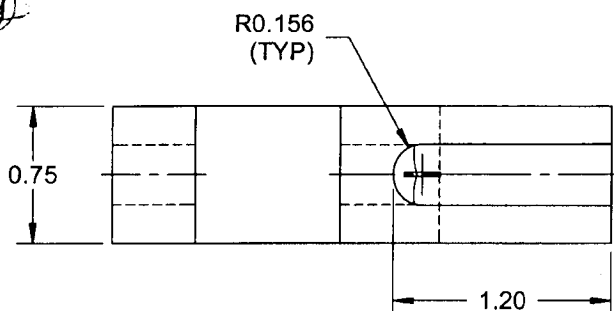
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

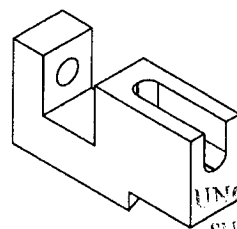
RELEASED  
036/02/09



### D3353-15 LOCK BRACKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW  
SCALE 1:2

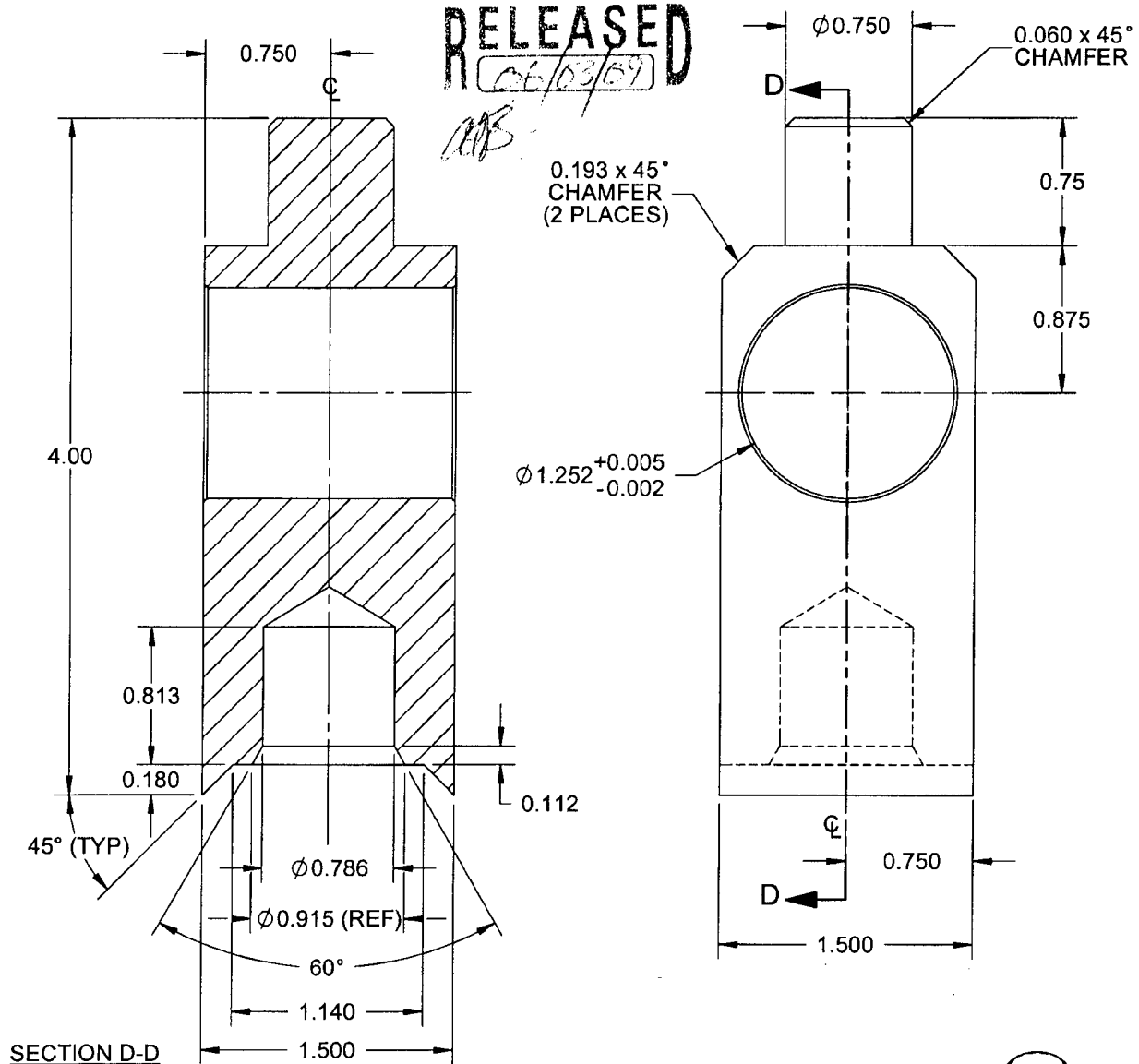
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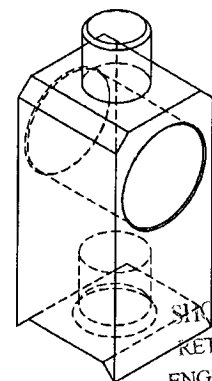
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26804

Work Order: 26804
Part Number: 03353-3
Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.46	✓		vern	
2.256	✓		vern	
0.38	✓		vern	
3.85	✓		vern	
0.333	✓		vern	
0.560	✓		vern	

Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 06-05-03	Date: N/A

Revised by: KJRF	Approved
------------------	----------

*[Signature]*